



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3065-7

Job Sheet 180486



Part No: D3065-7

Job Qty: 60 ea

Part Name: Step Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea		8/3/18	0.00	0.00	Start Up Waterjet		SC 18/07/18
100	Waterjet	60 pcs		8/3/18	0.00	2.21	Waterjet1		SL 18/07/18
120	QC	60 pcs		8/3/18	0.00	0.00	QC8		38
140	Brake NC	60 pcs		8/3/18	0.02	1.85	Brake NC 1		SB 9-85 DAS
150	QC	60 pcs		8/3/18	0.00	0.00	QC5		38
160	HandFinish	60 pcs		8/3/18	0.00	1.06	HandFinish1		SA 18-09-31
170	QC	60 pcs		8/3/18	0.00	0.00	QC7-2		
180	Packaging	60 pcs		8/3/18	0.00	0.00	Packaging3-1		
190	QC21-SA	60 Ea		8/3/18	0.00	0.00	QC21		DAS 21 JUL 31 2018

Part Op 100 - 1-Cut as per Dwg D3065

Descriptions: 140 - Bend as per Dwg D3065

180 - LOCATION : GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	9.4440 sf (.1574 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	9	119	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	0.128inches + 0.005 - 0.000	0.133 0.128	0.129	
2	Step Spacer	0.865inches ± 0.005	0.870 0.860	0.862	
3	Step Spacer	4.522inches ± 0.010	4.532 4.512	4.514	
4	Step Spacer	0.250inches ± 0.010	0.260 0.240	0.251	
5	Step Spacer	2.093inches ± 0.010	2.103 2.083	2.095	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____ _____ _____	LOTV Effective : _____ Disposition			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S092460

Part: D3065 - 7

Job No: 180486

Serial No/Batch: S092460

Revision: _____
Inspector: _____
Exp Date: _____
Instructions: _____

Date: 07/17/18

Equip/Tooling		Supplier		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Power Loss/Surge		Positioned Wrong	
Handling/Pre		Training		Cuffs		Contamination		Folio/Program		Outside Dimensions	
Material		Use for Testing		Crushing		Countersink		Grain		Over/Under tolerance	
Internal Transport		Poor Information		Heat Treat		Cut Too Short		Weld		Part Incorrect	
Tribal Knowledge		Rushing		Wave/Twist in Tube		Instructions Incomplete/Unclear		Wrong Stock Pulled		Part Lost/Missing	
LOA		Product Improvement		Marks/Chatter		Drill Holes		Out of Sequence		Part Moved	
Substation		Process Improvement						Off-set		Drawing	
Past Expiry Date		Manufacturing Process						Mislabeled		Finish	
Misidentified		Past Due		OTHER :						Misread	
								Misaligned/off center		Turning Sequence	

5. 4

6	Step Spacer	3.936inches $\pm$ 0.005	3.941 3.931	3,935
7	Step Spacer	4.186inches $\pm$ 0.010	4.196 4.176	4,186
8	Step Spacer	1.250inches $\pm$ 0.005	1.255 1.245	1,251
9	Step Spacer	0.125inches $\pm$ 0.010	0.135 0.115	0,124
10	Step Spacer	Attribute		

Plex 7/6/18 1:37 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
OTHER : _____																									